

# Work Order ID 74120

Thursday, September 22, 2011 2:31:17 PM

Page 1

Item ID: D3264-1

Accept

Revision ID:

Item Name: Bracket

Start Date: 9/22/2011 Start Qty: 7.00

Required Date: 9/28/2011 Req'd Qty: 7.00

Reference:

Approvals:

Process Plan: *mk*

Date: 11-09-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3264

Rev A2

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 5.700" LONG

0.00

*mk 11/09/26*

*7*

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOILIO FA447

FOILIO REV: *AA*

DWG REV: *A*

DEBURR AS PER DWG

0.00

*SL 11-09-26*

*7*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3264-1

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Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 9/22/2011 Start Qty: 7.00

Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 7.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

JL 11-09-26



QC

Memo

0.00

Quality Control

7

0

130

QC8- Inspect parts - second check

0.00

amk 11/09/27



QC

Memo

0.00

Quality Control

7

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7

0 JL 11/09/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D3264-1

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Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 9/22/2011 Start Qty: 7.00

Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 7.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M118434

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 d 11/09/28  
coate

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

7x 82 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74120**

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Page 4

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 9/22/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 7.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/3

11-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, September 22, 2011 2:31:15 PM

Page 1

Work Order ID: 74120



Parent Item: D3264-1



Parent Item Name: Bracket

Start Date: 9/22/2011

Required Date: 9/28/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP A ☐ 04.09.02 ☐ New issue ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	4.2417		3.5			



6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT004

4.2417

112628

4.2417

3.5 on 9/21/09/26

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74120
<b>Description:</b> Bracket		<b>Part Number:</b> D3264-1
<b>Inspection Dwg:</b> D3264	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.687	/		Verh. SL-3	
0.063	+/-0.010	.061	/			
0.125	+/-0.010	.124	/			
0.875	+0.010/-0.020	.875	/			
0.062	+/-0.010	.063	/		R-G	
R0.03	+/-0.030	.03	/		R-G	
R0.13	+/-0.030	.125	/			
1.00	+/-0.030	1.00	/			
0.125	+/-0.010	.126	/			
0.600	+/-0.010	.600	/			
4.000	+/-0.005	4.000	/			
0.750	+/-0.010	.750	/			
Ø0.194	+0.005/-0.000	.194	/			
5.50	+/-0.030	5.500	/			
0.125	+/-0.010	.126	/			
0.063	+/-0.010	.065	/			
R0.25	+/-0.030	.25	/		R-G	
4.27	+/-0.030	4.271	/			
R0.30	+/-0.030	.300	/			

<b>Measured by:</b> SL	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-09-26	<b>Date:</b> 11/09/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

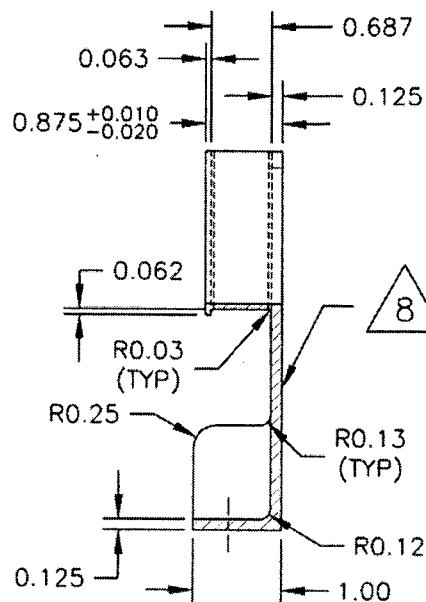
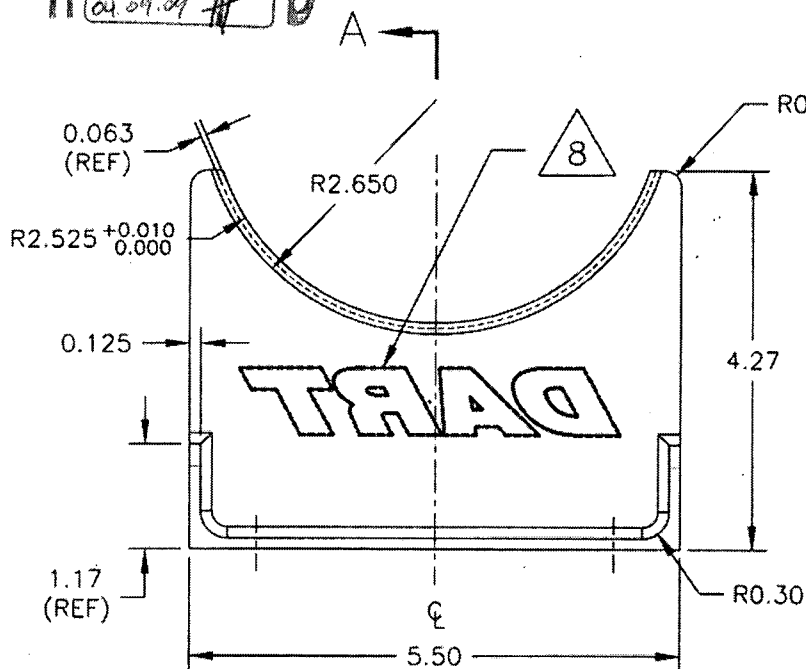
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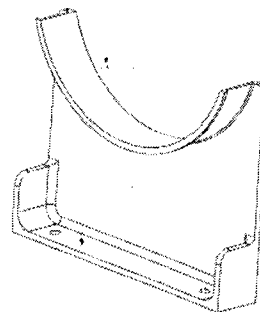
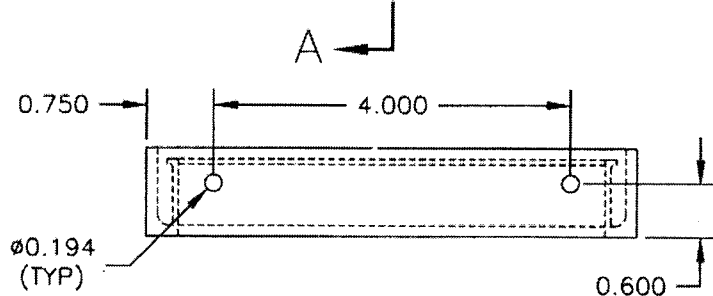


DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. REV. A D3264 SHEET 1 OF 1	
DATE 04.04.20		TITLE BRACKET		SCALE 1:2	
A	04.04.20		NEW ISSUE		

RELEASED  
04.09.09



**SECTION A-A**



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH  
(MIN) TOOL RADIUS OF 0.25

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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